

Date: Tuesday, 11/11/2008 12:46:46 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 43317		
Estimate Number	: 12973		
P.O. Number	:	Part Number	: D36461
This Issue	: 11/11/2008 S.O. No. :	Drawing Number	: D3646 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	: 38943	Material	:
Written By	:	Due Date	: 28/11/2008
Checked & Approved By	: <u>JUD 08.11.11</u>	Qty:	12 Um: Each
Comment	: Est Rev. A new issue 07.07.25 EC verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	M304TR0500W035	304 RD Tube .500 x .035W
-----	----------------	--------------------------



Comment: Qty.: 2.0790 f(s)/Unit Total: 24.9480 f(s)
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

Batch: M108250

SB 08/11/24 (12)

2.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Punch to length as per Dwg D3646 & template DT8958

SB 08/11/24 (12)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr 08/11/26 (12) Hm

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/27 (12)

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

8:15
320 OF

M-1 08/11/28

(12X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A.	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/11/2008 12:46:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 43317

Part Number: D36461

Job Number:



Seq. #:

Machine Or Operation:

Description:

FINISH TIME:

8:45

M-F 08/11/28

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



SL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-28

(12)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 226

PC 8/11/28 (12)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-F 08-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

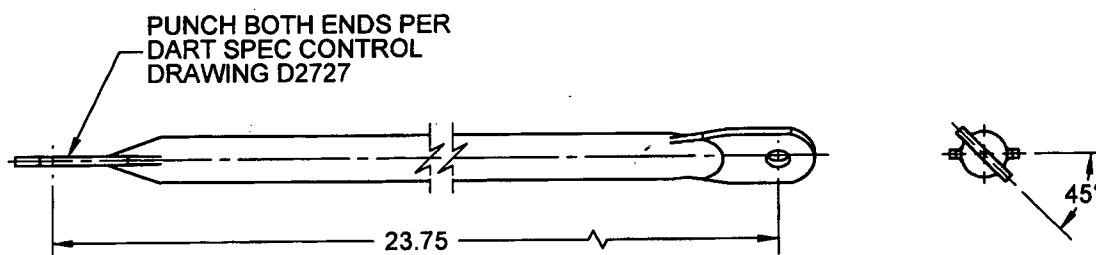
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3646	REV. A SHEET 1 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:2
REV A	DATE 07.06.06	DESCRIPTION NEW ISSUE	

RELEASED07.07.11 *[Signature]***D3646-1 ARM****NOTES:**

- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

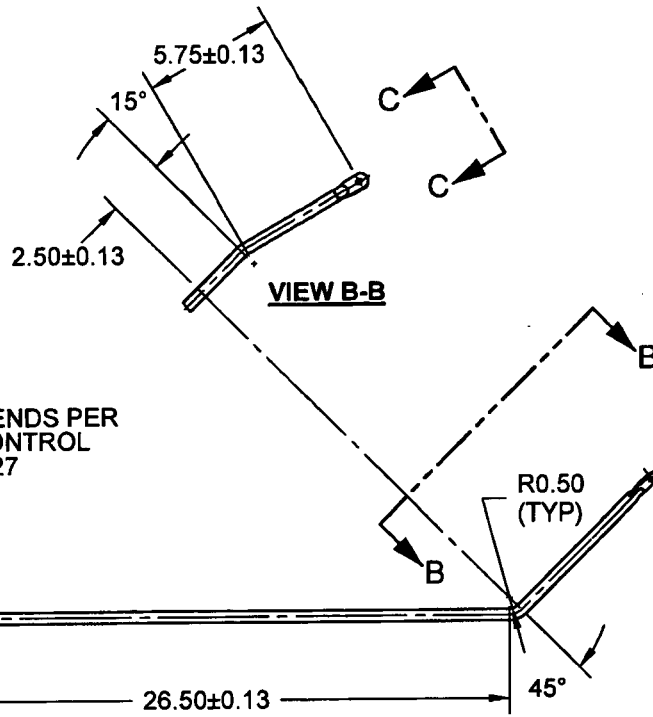
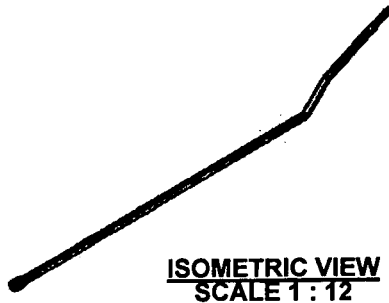
NO. 4397

COPYRIGHT © 2007 BY DART AEROSPACE LTD

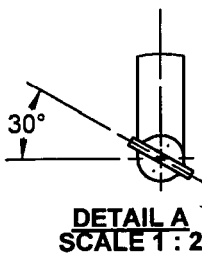
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3646	REV. A SHEET 2 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:8

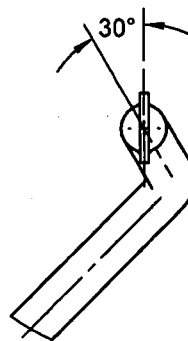


PUNCH BOTH ENDS PER
DART SPEC CONTROL
DRAWING D2727



RELEASED

07-07-11



D3646-3 ARM

NOTES:

- 1) MAKE PER TEMPLATE DT8959
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43317

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.